

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013592**Date Inspected:** 24-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dan Hernandez was present during the times noted above to observe the fit up, welding and related activities associated with the fabrication of the San Francisco Oakland Bay Self Anchored Suspension Bridge at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

OBG Trial Assembly Yard

Segment 7AE/7BE

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as DP662-001-020. The welder is identified as #054467 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-345-SMAW-3G (3F)-FCM-repair-1 UT repair for WR11321.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SP461-001-035. The welder is identified as #054467 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-345-SMAW-3G (3F)-FCM-repair-1 UT repair for WR11322.

This QA Inspector observed ZPMC personnel performing Magnetic Particle Testing of Side Plate Wt stiffener hold back fillet welds, bike path side.

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This QA Inspector observed ZPMC personnel performing Ultrasonic Testing of Edge Plate to Side Plate CJP splice, bike path and cross beam side.

Segment 7BW/7CW

This QA Inspector observed removal of remaining portion of fit up plate by grinding along the interior of the Deck Plate CJP splice.

Segment 7BE/7CE

This QA Inspector observed back gouging of UT rejects in Edge Plate top I rib CJP web splice, bike path side.

This QA Inspector observed ZPMC personnel performing Ultrasonic Testing of Deck Plate I rib CJP web splice, cross beam side.

Segment 7CE

This QA Inspector observed ABF personnel performing Ultrasonic Testing of the Deck Plate to Edge Plate CJP splice, bike path side.

ZPMC Quality Control (QC) Inspector is identified as Fang Ya Jun. QA Inspector observed QC Inspector verify welding parameters. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Plate Yard

This QA Inspector selected two (2) 460mm x 355mm plate check samples and assigned a QA Lot number to each of following sampled material:

Item 723: 45mm A709M-345F2-X-Z, HT# 09208184, Lot# B222-004-10

Item 724: 35mm A709M-345F2-X-Z, HT# 09208176, Lot# B222-003-10

Samples were marked with Lot number, Item number, material thickness, date and direction of rolling. Samples will be shipped to an Independent Testing lab.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372 , who represents the Office of Structural Materials for your project.

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Inspected By:	Hernandez,Dan	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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